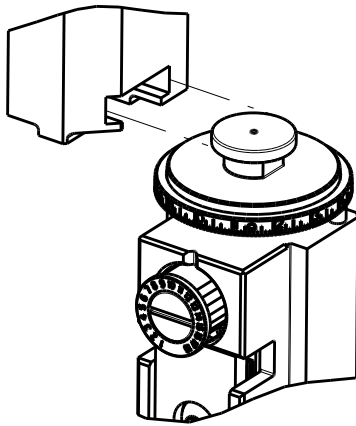


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	
	2151057-1	E	FINE CRIMP HEIGHT ADJUST	
	2151057-2	E	FINE CRIMP HEIGHT ADJUST	
	2151057-5	E	FINE CRIMP HEIGHT ADJUST	
	2151057-6	E	NON-CRIMP HEIGHT ADJUST	
	2151057-7	E	FINE CRIMP HEIGHT ADJUST	
	7-2151057-7		B	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [1.130]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.6 X 0.6 MM TYP A			
WIRE STRIP LENGTH 3.70-4.30 mm [1.46-.169 IN]		 INSULATION DIAMETER RANGE Ø 2.60mm MAX [1.02 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18082	-	-
	(B)114-18081	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INS RANGE
(A) 964269-2	(B) 964274-2	1394133-1		1.2-1.6mm
(A) 964269-3	(B) 964274-3	963530-1		1.4-1.9mm
(A) 964269-5	(B) 964274-6	964972-1		1.9-2.4mm
(B) 4-964274-1				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20+/-0.05 [1.047+/- .002]	3.0
0.75mm2	1.18+/-0.05 [1.046+/- .002]	3.8
0.5mm2	1.15+/-0.05 [1.045+/- .002]	4.8



1 RECOMMENDED SPARE PARTS

2 GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151057-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151057-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151057-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151057-6

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50.

7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12 WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
APPLY #1-23419-5 LOC-TITE TO THREADS.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO TIMER 2 CONTACT			
WIRE STRIP LENGTH 3.70-4.30 mm [1.46-.169 IN]		INSULATION DIAMETER RANGE Ø 2.60mm MAX [1.02 IN MAX]	
TERMINAL APPLICATION SPECIFICATION  (B)114-18081		- -	

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INS RANGE
(B) 1241732-2		964971-1		1.2-1.6mm
(B) 4-1241732-1		963530-1		1.4-1.9mm
		964972-1		1.9-2.4mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [1.054+/- .002]	3.5
0.75mm2	1.27+/-0.05 [1.050+/- .002]	4.4
0.5mm2	1.18+/-0.05 [1.046+/- .002]	5.3

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

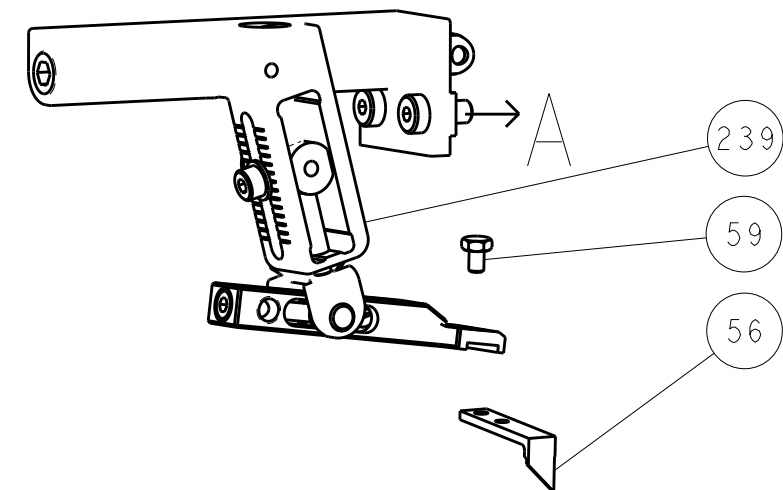
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISONS			
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			C		ECR-13-005181	22MAR2013
			D		ECR-14-005497	14APR2014
			E		ECR-15-000965	21JAN2015

-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	3	992763-5	SCR, SKT, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1	1-1752354-8	STANDOFF,HOLD-DOWN	50
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-8	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1333204-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2119784-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

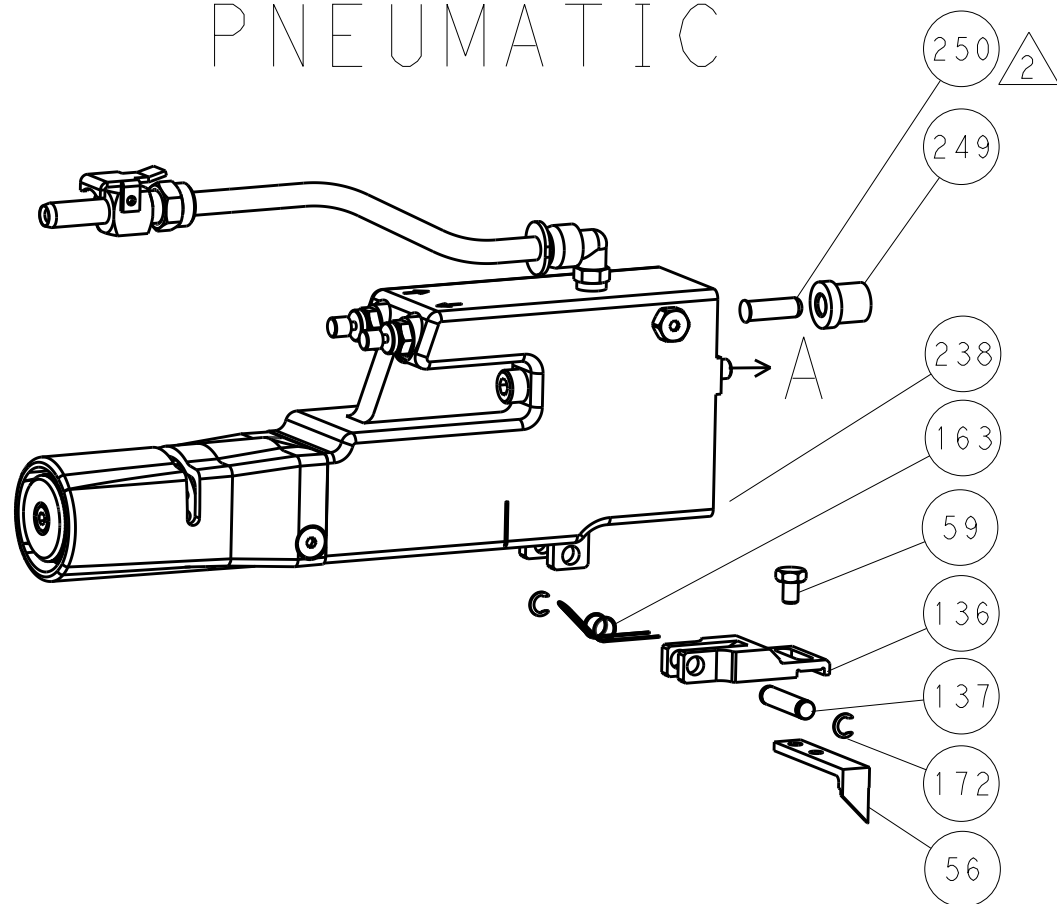
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER'S ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN B. WEAVER	03OCT2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK L. GROSS	03OCT2011	NAME	
mm		APVD G. BAILEY	03OCT2011	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE	
0 PLC ±.5		APPLICATION SPEC		CASE CODE	
1 PLC ±0.5		WEIGHT		DRAWING NO	
2 PLC ±0.13		MATERIAL		00779	
3 PLC ±0.013		FINISH		©=2151057	
4 PLC ±0.0001		Customer Accessible Production Drawing		RESTRICTED TO	
ANGLES ±.5		SCALE		1:2	
		SHEET		1 OF 4	
		REV		E	

LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

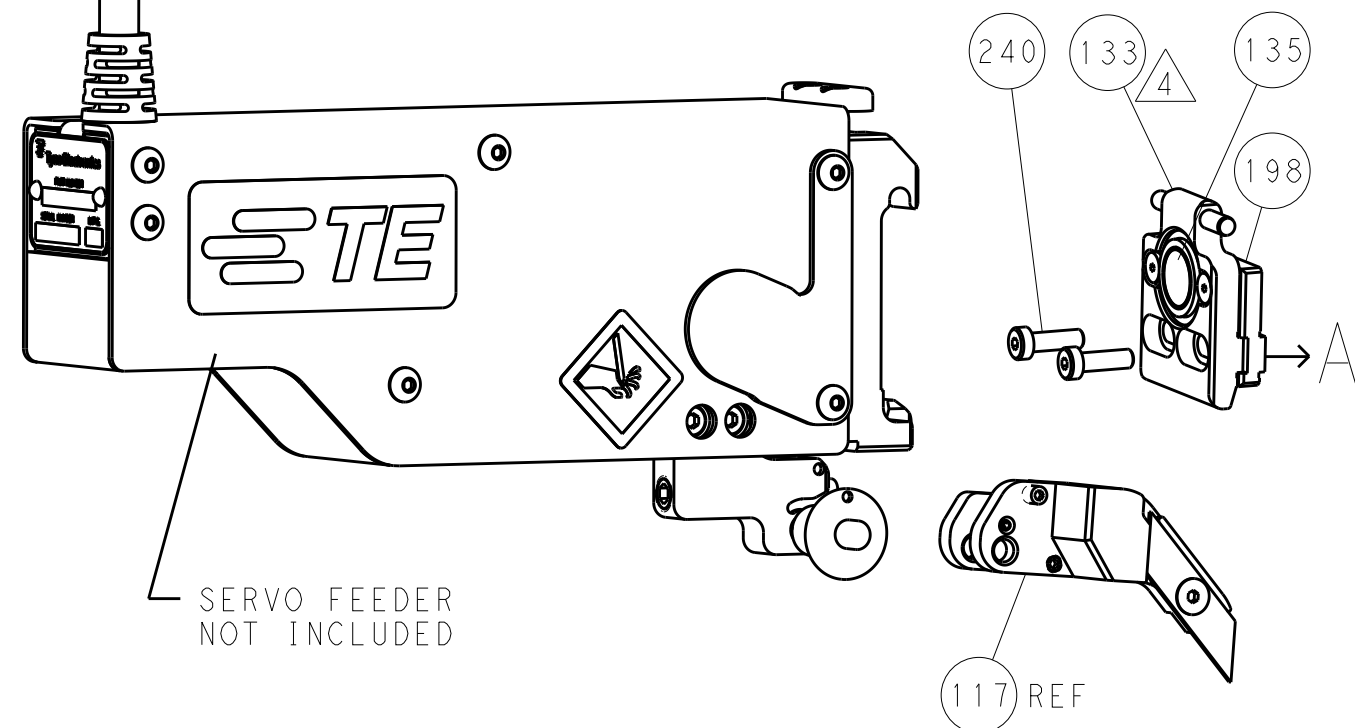
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MECHANICAL



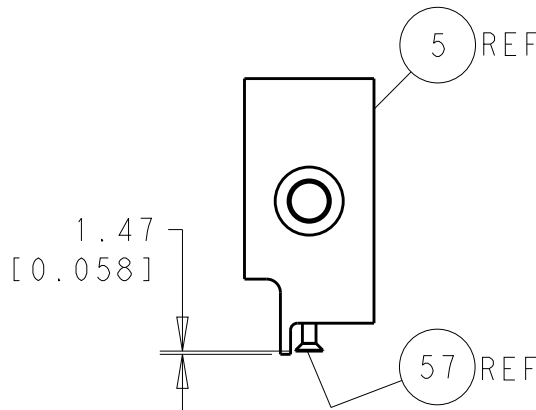
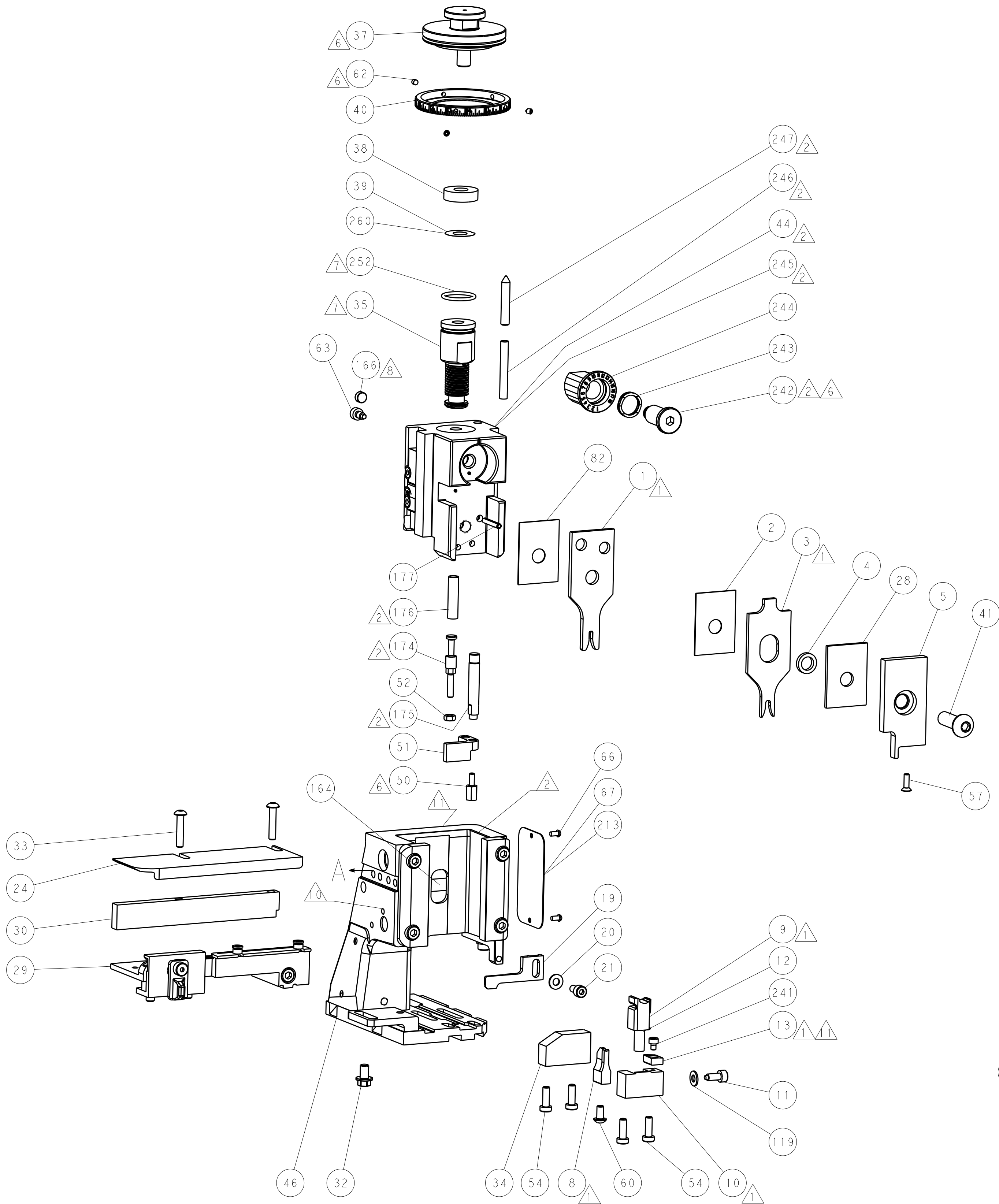
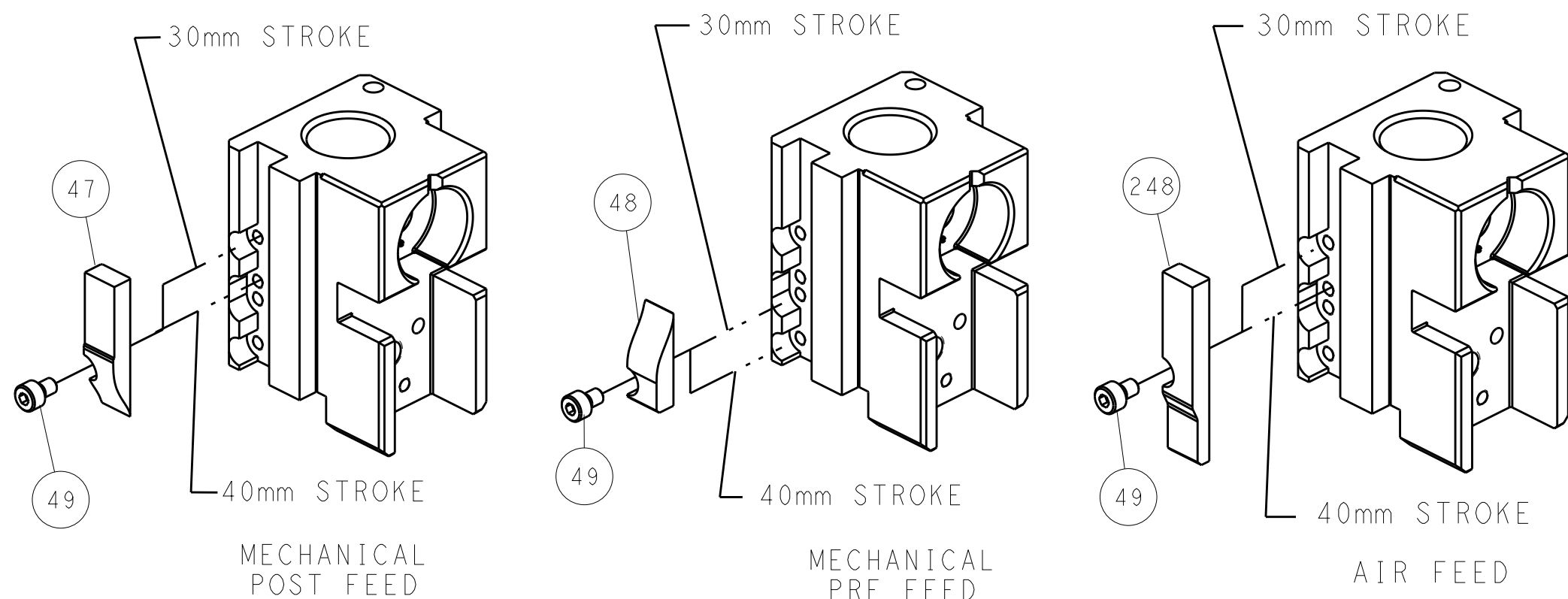
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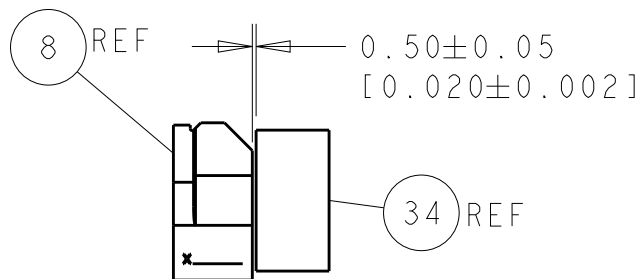
SERVO
LATCH PLATE



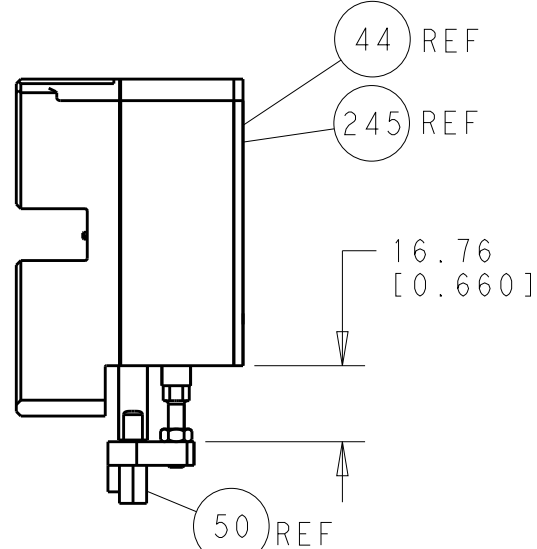
CAM POSITIONS



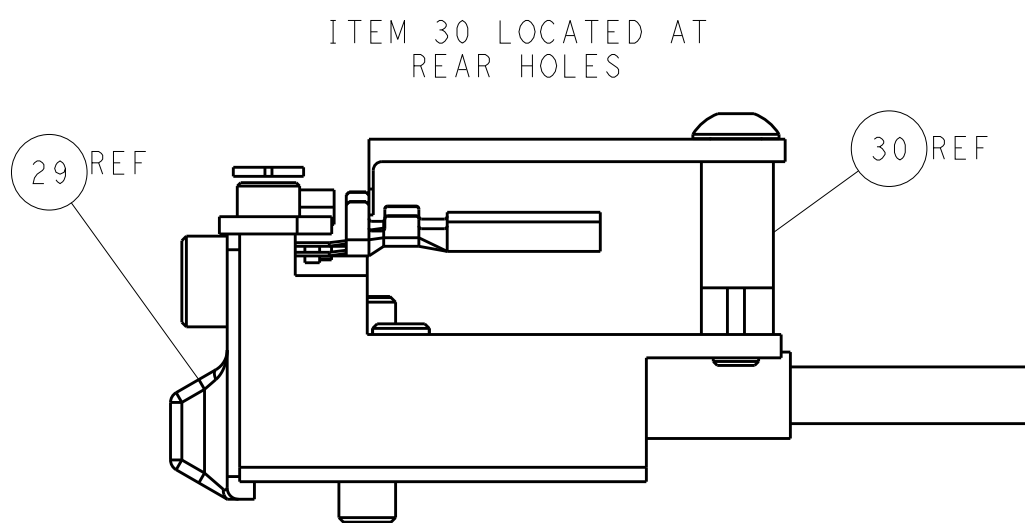
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



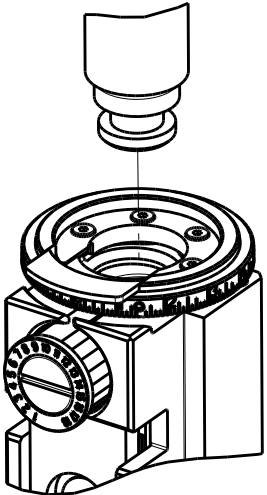
HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

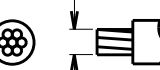
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	B. WEAVER	03OCT2011	TE Connectivity Harrisburg, PA 17105-3608				
				CHK	L. GROSS	03OCT2011					
				APVD	G. BAILEY	03OCT2011	NAME Ocean Side Feed Applicator -				
				PRODUCT SPEC							
				APPLICATION SPEC							
				WEIGHT							
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV E					

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2151057-1	E	FINE CRIMP HEIGHT ADJUST
	2-2151057-2	E	FINE CRIMP HEIGHT ADJUST
	2-2151057-5	E	FINE CRIMP HEIGHT ADJUST
	2-2151057-7	E	FINE CRIMP HEIGHT ADJUST
	7-2151057-7	B	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-10389 		

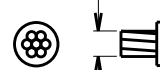
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION		
TERMINAL NAME: TAB 1.6 X 0.6 MM TYP A				
WIRE STRIP LENGTH 3.70-4.30 mm [.146-.169 IN]		INSULATION DIAMETER RANGE Ø 2.60mm MAX [.102 IN MAX]		
TERMINAL APPLICATION SPECIFICATION				
(A)114-18082		-	-	
(B)114-18081		-	-	
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INS RANGE
(A) 964269-2	(B) 964274-2	1394133-1		1.2 - 1.6mm
(A) 964269-3	(B) 964274-3	963530-1		1.4 - 1.9mm
(A) 964269-5	(B) 964274-6	964972-1		1.9 - 2.4mm
	(B) 4-964274-1			

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
1.00mm2	1.20+/-0.05 [.047+/- .002]	3.0
0.75mm2	1.18+/-0.05 [.046+/- .002]	3.8
0.5mm2	1.15+/-0.05 [.045+/- .002]	4.8



-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151057-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151057-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151057-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
-  MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
-  CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
-  SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
-  TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
-  THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
-  APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION		
TERMINAL NAME: MICRO TIMER 2 CONTACT				
WIRE STRIP LENGTH 3.70-4.30 mm [.146-.169 IN]		INSULATION DIAMETER RANGE Ø 2.60mm MAX [.102 IN MAX]		
TERMINAL APPLICATION SPECIFICATION (B)114-18081				
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INS RANGE
(B) 1241732-2		964971-1		1.2-1.6mm
(B) 4-1241732-1		963530-1		1.4-1.9mm
		964972-1		1.9-2.4mm

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
1.00mm2	1.36+/-0.05 [.054+/- .002]	3.5
0.75mm2	1.27+/-0.05 [.050+/- .002]	4.4
0.5mm2	1.18+/-0.05 [.046+/- .002]	5.3

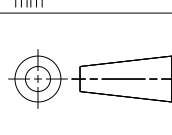
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

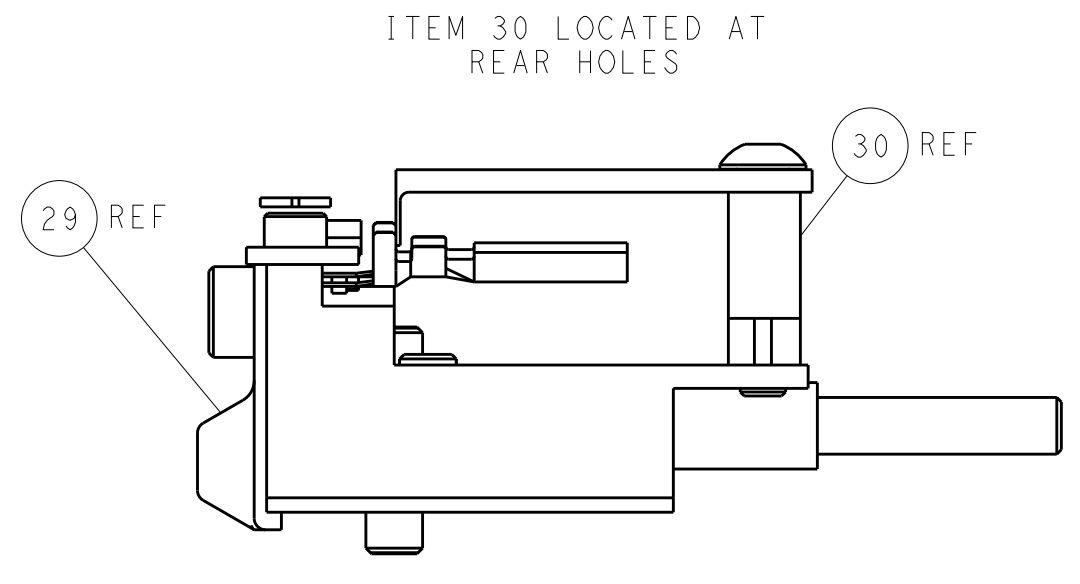
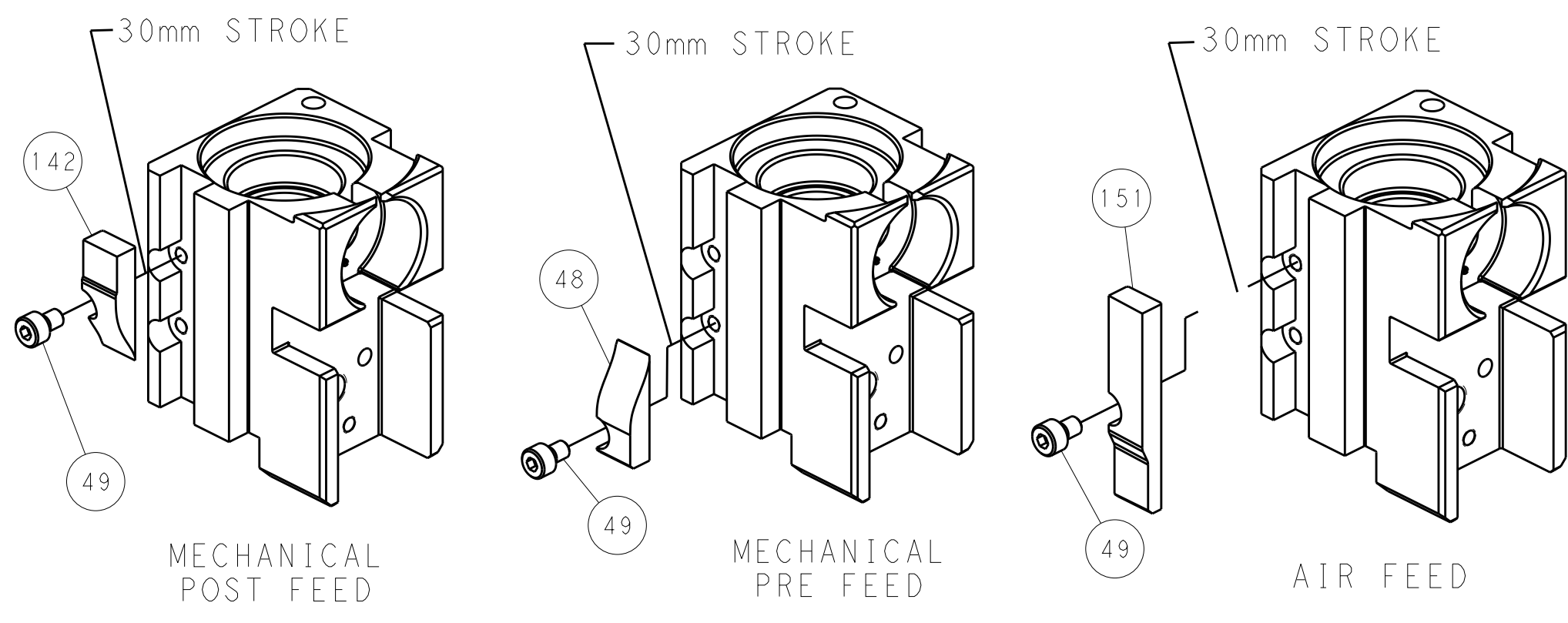
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

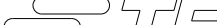
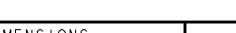
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DIMENSIONS: mm		CHK L. GROSS 03OCT2011	NAME Ocean Side Feed Applicator	
		APVD G. RALLEY 03OCT2011	SIZE 00779	
		PRODUCT SPEC	CAGE CODE 00779	
MATERIAL -		FINISH -	DRAWING NO 00779	
Customer Accessible Production Drawing		WEIGHT -	RESTRICTED TO -	
SCALE 1:2		SHEET 3		REV E

CAM POSITIONS



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.005 1 PLC ±.01 2 PLC ±.013 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1°		NAME: Ocean Side Feed Applicator SIZE: A CASE CODE: 00779 DRAWING NO: C-2151057	
		PRODUCT SPEC: - APPLICATION SPEC: -		RESTRICTED TO: -	
MATERIAL: - FINISH: -		WEIGHT: -		SCALE: 1:2 SHEET 4 OF 4 REV E	
Customer Accessible Production Drawing					

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